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RBEM632V3013101
Job Sheet 182022



005934

Part No: RBEM632V3013101

Job Qty: 1 pcs

Part Name: Servo-Control Fittings Nut Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/15/18

Job Tracking No:

Due Date: 9/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3013101 Rev. 1 IPP Rev. A 18.03.07 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/4/18	9/4/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs	9/4/18	9/4/18	0.00	0.00	Small Fab-5		MLC DAS 38
120	QC	1 pcs	9/4/18	9/4/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	9/4/18	9/4/18	0.00	0.00	Packaging3-1		MLC 9.80
140	QC	1 pcs	9/4/18	9/4/18	0.00	0.00	QC21		DAS 21 9.80

OCT 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5075949
137A APP-1510-E	Case	1 Ea (1 ea)	110-Small Fab	5112929
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
G4 RBEM632V3013101-1	Shim	1 Ea (1 ea)	110-Small Fab	5114125
134B RBEM632V3013101-11	Short Strap	1 Ea (1 ea)	110-Small Fab	5015886
137A RBEM632V3013101-13	Long Strap	1 Ea (1 ea)	110-Small Fab	5015882
RBEM632V3013101-17	Bottom Foam 5.79 X 11.26 X 20.12 (Ethafom 220, Black)	1 pcs (1 ea)	110-Small Fab	5112924
RBEM632V3013101-19	Top Tool Cushion 1.79 X 11.26 X 20.12 (Ethafom 220, Black)	1 pcs (1 ea)	110-Small Fab	5112926
RBEM632V3013101-3	Lock Wrench <i>Sylvain got w/b</i>	1 Ea (1 ea)	110-Small Fab	5118241
134B RBEM632V3013101-9	Placard, Plastic	1 Ea (1 ea)	110-Small Fab	5107819

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	579	0
110-Small Fab	APP-1510-E	1	2	0
	RB41011	1	803	0
	RBEM632V3013101-1	1	0	0
	RBEM632V3013101-11	1	18	0
	RBEM632V3013101-13	1	19	0
	RBEM632V3013101-17	1	0	0
	RBEM632V3013101-19	1	0	0
	RBEM632V3013101-3	1	0	0
	RBEM632V3013101-9	1	0	0

DART
AEROSPACE

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Container No: S118651

Part: RBEM632V3013101

Job No: 182022

Serial No/Batch: S118651

Revision: 1

Inspector:

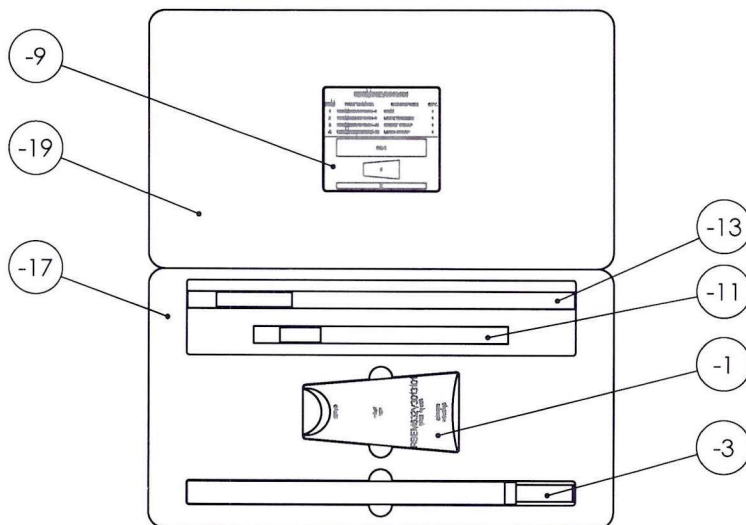
Exp Date:

Instructions:

Date: 10/6/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	11/3/2016	DPD	JAG



NOTE:
REF. AIRBUS T/N: RBEM632V3013101.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SHIM	WHITE NYLON		2
	X		-3	1	LOCK WRENCH			3
	1		-5		ROD	1018/1020 CR		4
	1		-7		COVER	6061		5
			-9	1	PLACARD	PLASTIC		6
		B/O	-11	1	SHORT STRAP	NYLON	(OLYMPIC SYNTHETICS)	7
		B/O	-13	1	LONG STRAP	NYLON	(OLYMPIC SYNTHETICS)	8
	1	B/O	-15		SPRING PIN	STEEL	M3 X 22mm (MCMASTER-CARR #91611A160)	3
		B/O	-17	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	5.79 X 11.26 X 20.12 (CASE SOLUTIONS)	9
		B/O	-19	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.79 X 11.26 X 20.12 (CASE SOLUTIONS)	10
		B/O	-21	1	CASE	PLASTIC	PELICAN #APP-1510-E	N/S
		B/O		1	PLACARD	ALUMINUM	RB41011	N/S
	ASSY -3							

DART AEROSPACE

TITLE: **SERVO-CONTROL FITTINGS NUT GUIDE**

DWG NO. **RBEM632V3013101** REV **1**

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:8	DATE 6/14/2016
	SHEET 1 OF 10

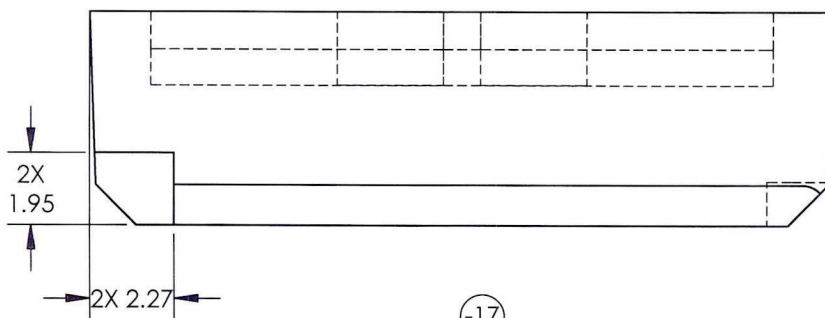
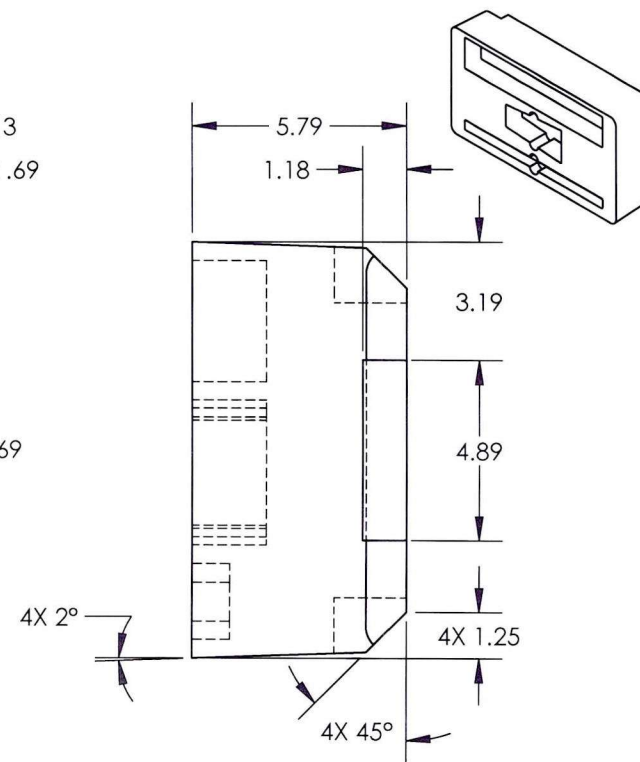
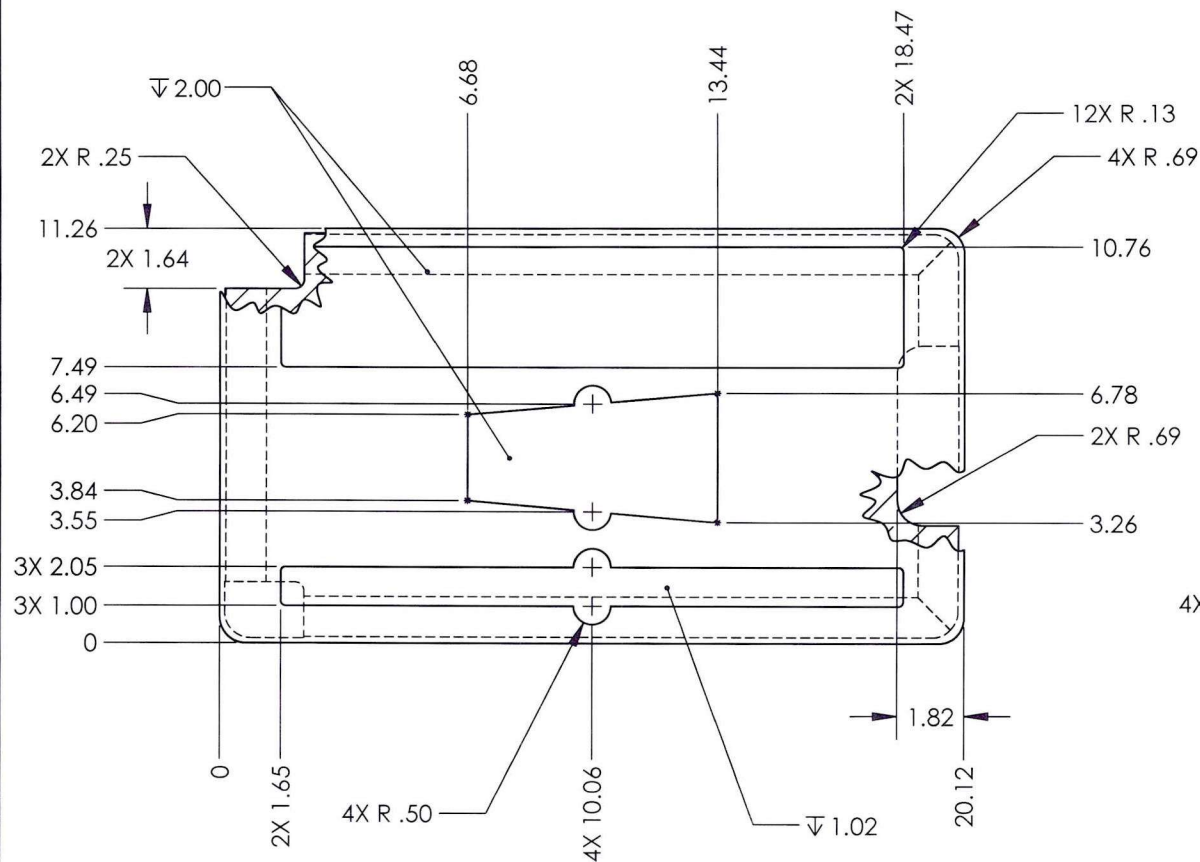
Part Specifications

Specifications could not be found.

Plex 8/15/18 5:07 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

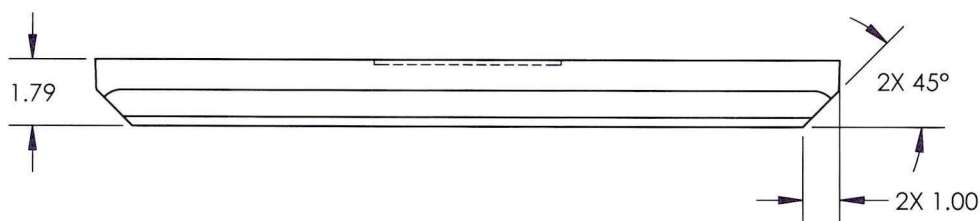
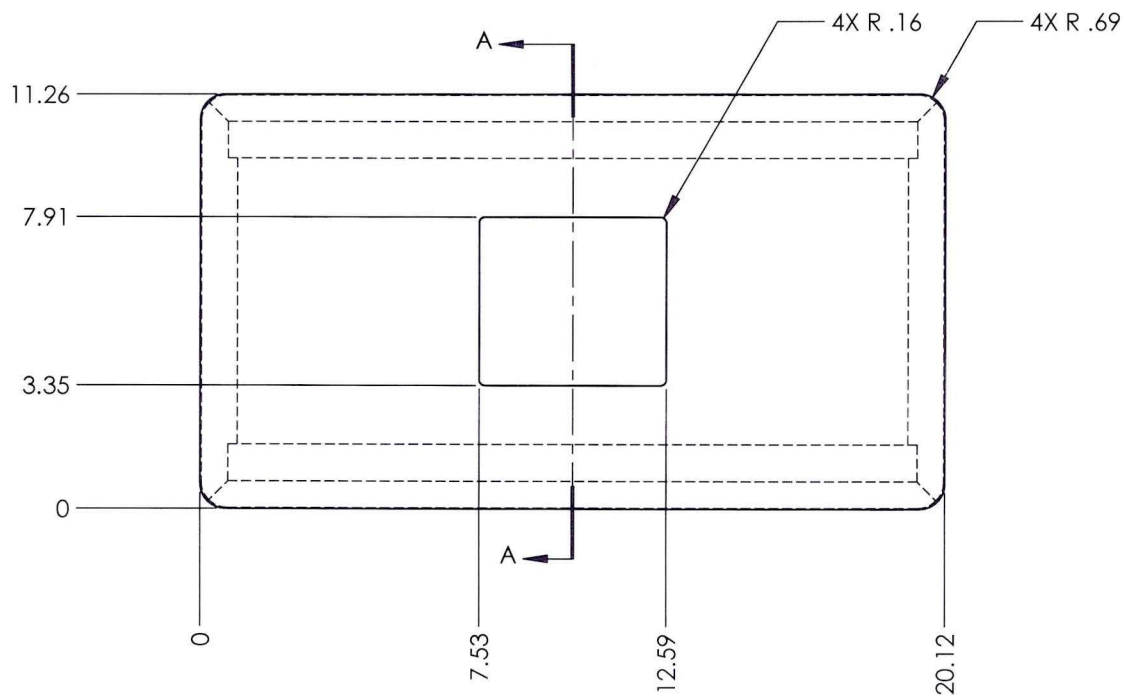
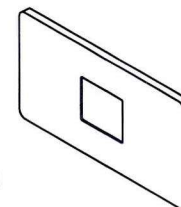


(17)
BOTTOM FOAM

DART AEROSPACE	
TITLE SERVO-CONTROL FITTINGS NUT GUIDE	
DWG NO. RBEM632V3013101-17	REV 1
MAT'L ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/✓
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 6/14/2016
SHEET 9 OF 10	

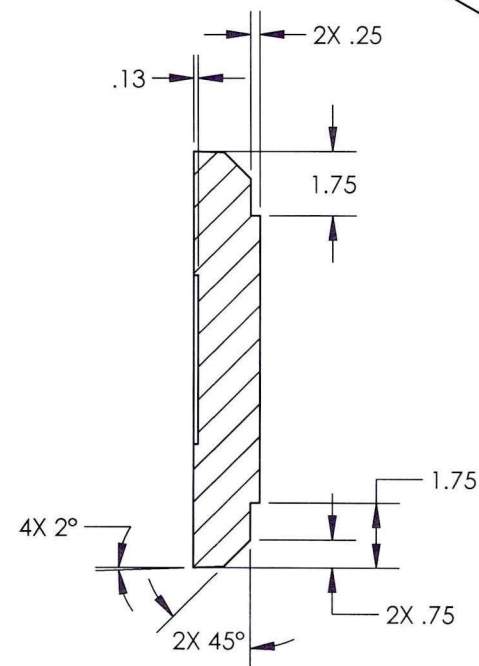
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(-19)

TOP TOOL CUSHION



SECTION A-A



TITLE SERVO-CONTROL FITTINGS NUT GUIDE

DWG NO. RBEM632V3013101-19 REV 1

MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT		.XXX ± .010	FRACTIONS ± 1/8
TREAT		.XX ± .03	ANGLES ± 1°
FINISH		.X ± .1	SURFACES = 125/
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	ANDERSON	USED ON MODEL	
QA APPR:	LINDSAY	H175	
APPROVED:	GILBERT		
SCALE	1:5	DATE	6/14/2016
		SHEET 10 OF 10	